

Work Order ID 165092

Tuesday, August 15, 2017

Page 1

Item ID: Revision ID:

Item Name:

Draw Nbr:

Start Date: 8/15/2017 9:2

Start Qty: 1.0000

Revision Nbr

Required Date: 8/15/2017 9:2

Reqd Qty: 1.0000

Reference: ECN 17-615

Cust Item ID:

Customer ID:

Description: UPDATE PAPER WORK PER ECN 17-615
DOCUMENT AFFECTED ICA D206-642 REV. 7

Sales Order:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ DATE 15 2017 SPC (Y/N): _____ Date: _____

Hours

Sequence Work Center Operation

Set Up Run

Tool ID Tool # Plan Accept Reject Insp.

DAS
28
9-89

SEP 13 2017

DAS
21
9-89

SEP 14 2017

AC21-17/9/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

List Lots

Page 1 of 9

Monday, August 14, 2017 8:54:03 AM

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',							
D206-642-149	Main Warehouse	81749	6/30/2016	3.0000	QC21	CHG001	DAS 28 9-89
Run-on Landing Wearplates, FG128A							
Low Gear 206A/B Fits LH or RH							
	Main Warehouse	87608	6/30/2016	4.0000	QC21	CHG001	DAS 28 9-89
	FG128A						
	OFFSHORE	81749	6/30/2016	1.0000	QC21	CHG001	
	FG						
			Total:	8.0000			
D206-642-213	Main Warehouse	112241	6/27/2014	1.0000	QC21	CHG007	
Skidtube LH, High Gear, Thru-Bolt, Std Wearplates (2" Bolt Spacing on Aft Saddle)	FG083						
			Total:	1.0000			
D206-642-214	Main Warehouse	106920	5/3/2016	1.0000	QC21	CHG007	
Skidtube RH, High Gear, Thru-Bolt, Std Wearplates (2" Bolt Spacing on Aft Saddle)	FG083						
			Total:	1.0000			
D206-642-217	Main Warehouse	108823	5/4/2016	1.0000	QC21	CHG002	
Skidtube LH, High Gear, Thru-Bolt, Run-on Landing (2" Bolt Spacing on Aft Saddle)	FG083						
			Total:	1.0000			
D206-642-218	Main Warehouse	108917	5/4/2016	1.0000	QC21	CHG002	
Skidtube RH, High Gear, Thru-Bolt, Run-on Landing (2" Bolt Spacing on Aft Saddle)	FG083						

SEP 13 2017

SEP 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Monday, August 14, 2017 8:54:03 AM

Page 2 of 9

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D206-642-241	Main Warehouse	113636	Total:	1.0000			DAS	
Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH	FG083		5/9/2017	1.0000	QC21	CHG006	28	SEP 13 2017
	OFFSHORE	101553	5/9/2017	1.0000	QC21	CHG006	9-89	
	FG							
	OFFSHORE	98943	5/9/2017	1.0000	QC21	CHG006		
	FG							
D206-642-249	Main Warehouse	56615	Total:	3.0000			DAS	
Run-on Landing Wearplates, High Gear 206A/B Fits LH or RH	FG127		5/3/2016	2.0000	QC21	CHG001	28	SEP 13 2017
	Main Warehouse	78220	5/3/2016	1.0000	QC21	CHG001	9-89	
	FG128A							
D206-642-311	Heli Tech	151674	Total:	3.0000			DAS	
Skidtube LH, Low & High Gear with Standard Wearplates	FG		6/16/2017	1.0000	QC21	CHG008	28	SEP 13 2017
	OFFSHORE	157730	6/28/2017	1.0000	QC21	CHG008	9-89	
	FG							
D206-642-311BL	Main Warehouse	163616	Total:	2.0000				
Skidtube LH (Ael Blue)	FG082		8/8/2017	1.0000	QC21	CHG008		
	OFFSHORE	106434	8/8/2017	1.0000	QC21	CHG007		
	FG							

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 2 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

List Lots

Monday, August 14, 2017 8:54:03 AM

Page 3 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

			Total:	2.0000		
D206-642-312	Heli Tech	153428	5/9/2017	1.0000	QC21	CHG008
Skidtube RH, Low & High Gear with Standard Wearplates	FG					
	OFFSHORE	152808	5/9/2017	1.0000	QC21	CHG008
	FG					
			Total:	2.0000		
D206-642-312BL	Main Warehouse	163625	8/9/2017	1.0000	QC21	CHG008
Skidtube RH, Low & High Gear with Standard Wearplates (Ael Blue)	FG082					
	Main Warehouse	163626	8/9/2017	1.0000	QC21	CHG008
	FG082					
	Main Warehouse	163627	8/9/2017	1.0000	QC21	CHG008
	FG082					
	Main Warehouse	163628	8/9/2017	1.0000	QC21	CHG008
	FG082					
	Main Warehouse	163629	8/9/2017	1.0000	QC21	CHG008
	FG082					
			Total:	5.0000		
D206-642-313	Main Warehouse	160287	5/31/2017	1.0000	QC21	CHG001
Skidtube LH, Low & High Gear with Run-on Landing Wearplates	FG083					
			Total:	1.0000		

GONE

DAS
28
7-89

SEP 13 2017

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 3 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : 	
Misidentified ☐	Past Due ☐																																																														

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Page 4 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

D206-642-314	Main Warehouse	160288	5/31/2017	1.0000	QC21	CHG001	DAS 28 9-89	SEP 13 2017
Skidtube RH, Low & High Gear with Run-on Landing Wearplates								
Total:				1.0000				
D206-642-341	Main Warehouse	158259	6/16/2017	1.0000	QC21	CHG005		
Replacement Skidtube (Fits LH or RH)								
Total:				1.0000				
D206-642-413	Main Warehouse	146593	8/17/2016	1.0000	QC21	CHG001	DAS 28 9-89	SEP 13 2017
Skidtube LH, High Gear with Run-on Landing Wearplates								
Total:				1.0000				
D206-642-414	Main Warehouse	140865	8/17/2016	1.0000	QC21	CHG001	DAS 28 9-89	SEP 13 2017
Skidtube RH, High Gear with Run-on Landing Wearplates								
Total:				1.0000				
D206-642-441BL	Main Warehouse	131403	5/3/2016	1.0000	QC21	CHG005	DAS 28 9-89	SEP 13 2017
Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH								
Total:				1.0000				
D206-642-451	Main Warehouse	150263	4/20/2017	1.0000	QC21	CHG001	DAS 28 9-89	SEP 13 2017
Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH								
Total:				1.0000				

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Page 4 of 9

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

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Page 5 of 9

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D206-642-511 Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	OFFSHORE	144959	3/15/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	147143	6/28/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	147144	3/15/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	158196	6/28/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	158197	6/28/2017	1.0000	QC21	CHG006
	FG					
	Total:			5.0000		
D206-642-511RLC Skidtube LH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	OFFSHORE	153391	2/15/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	153392	2/15/2017	1.0000	QC21	CHG006
	FG					
	Total:			2.0000		
D206-642-512 Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	OFFSHORE	121740	6/28/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	123572	6/28/2017	1.0000	QC21	CHG006
	FG					

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 5 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

List Lots

Monday, August 14, 2017 8:54:03 AM

Page 6 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

D206-642-512	OFFSHORE	124679	3/8/2017	1.0000	QC21	CHG006
Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	FG					
	OFFSHORE	147146	3/8/2017	1.0000	QC21	CHG006
	FG					
	OFFSHORE	158044	6/28/2017	1.0000	QC21	CHG006
	FG					
			Total:	5.0000		
D206-642-512RLC	OFFSHORE	153395	2/15/2017	1.0000	QC21	CHG006
Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	FG					
	OFFSHORE	153396	2/15/2017	1.0000	QC21	CHG006
	FG					
			Total:	2.0000		
D206-642-514	Main Warehouse	120010	5/12/2017	1.0000	QC21	CHG005
Skidtube RH,High Gear, Std Wearplates, DART(Apical) Tri-Bag & OEM/PMA Float Comp	FG073					
			Total:	1.0000		
D206-642-516	Main Warehouse	125201	4/9/2015	1.0000	QC21	CHG002
Skidtube RH,High Gear, Run-on Landing, DART (Apical) Tri-bag Float Comp.	FG073					
			Total:	1.0000		

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28 SEP 13 2017
9-89

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 6 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

List Lots

Monday, August 14, 2017 8:54:03 AM

Page 7 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

D206-642-518	Main Warehouse	131224	4/9/2015	1.0000	QC21	CHG002
Skidtube RH,High Gear, Run-on Landing, DART(Apical) Tri-Bag & OEM/PMA Float Comp	FG073					

DAS
28
9-89

SEP 13 2017

Total: 1.0000

D206-642-521PHI	Heli Tech	149841	2/13/2017	1.0000	QC21	CHG001
Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible	FG					

Heli Tech	149842	2/13/2017	1.0000	QC21	CHG001
FG					
OFFSHORE	149049	1/18/2017	1.0000	QC21	CHG001
FG					
OFFSHORE	149051	1/18/2017	1.0000	QC21	CHG001
FG					

Total: 4.0000

D206-642-522PHI	Heli Tech	149824	2/13/2017	1.0000	QC21	CHG001
Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible	FG					

Heli Tech	149843	2/13/2017	1.0000	QC21	CHG001
FG					
OFFSHORE	149054	2/10/2017	1.0000	QC21	CHG001
FG					
OFFSHORE	149823	2/10/2017	1.0000	QC21	CHG001
FG					

Total: 4.0000

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 7 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

List Lots

Monday, August 14, 2017 8:54:03 AM

Page 8 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

D206-642-541 OFFSHORE 147420 6/28/2017 1.0000 QC21 CHG005

Repl.Skid.,High Gear,Std
Wearplates Fits LH/RH,
DART Tri-Bag Float Comp.

Total: 1.0000

D206-642-545 OFFSHORE 68676 5/3/2016 1.0000 QC21 CHG002

Repl.Skid.,High Gear,Std
Wearplates Fits LH/RH,
DART Tri-Bag,OEM/PMA
Float Comp.

Total: 1.0000

D206-642-611 Main Warehouse 113824 5/3/2016 1.0000 QC21 CHG006

Skidtube LH,High Gear,Std
Wearplates (2.5" Bolt
Spacing) Tri-Bag Float
Comp.

DAS
28
9-89

SEP 13 2017

Main Warehouse 132065 5/3/2016 1.0000

FG073

DAS
28
9-89

SEP 13 2017

OFFSHORE 81282 5/3/2016 1.0000 QC21 CHG004

FG

Total: 3.0000

D206-642-612 Main Warehouse 113574 5/3/2016 1.0000 QC21 CHG005

Skidtube RH,High Gear,Std
Wearplates (2.5" Bolt
Spacing),Tri-Bag Float
Comp.

DAS
28
9-89

SEP 13 2017

Main Warehouse 121399 5/3/2016 1.0000 QC21 CHG006

FG073

DAS
28
9-89

SEP 13 2017

OFFSHORE 90823 5/3/2016 1.0000 QC21 CHG004

FG

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 8 of 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

List Lots

Monday, August 14, 2017 8:54:03 AM

Page 9 of 9

Criteria : Item ID: 'D206-642-113', 'D206-642-114', 'D206-642-141', 'D206-642-149', 'D206-642-151', 'D206-642-212', 'D206-642-213', 'D206-642-214', 'D206-642-216', 'D206-642-217', 'D206-642-218', 'D206-642-241', 'D206-642-247', 'D206-642-249', 'D206-642-251', 'D206-642-251RevA', 'D206-642-311', 'D206-642-311BL', 'D206-642-311BL Repair', 'D206-642-312', 'D206-642-312BL', 'D206-642-312BL REPAIR', 'D206-642-313', 'D206-642-314', 'D206-642-341', 'D206-642-341BL', 'D206-642-351', 'D206-642-411', 'D206-642-411BL', 'D206-642-412', 'D206-642-412BL', 'D206-642-413', 'D206-642-414', 'D206-642-441', 'D206-642-441BL', 'D206-642-441RevF', 'D206-642-447', 'D206-642-451', 'D206-642-511', 'D206-642-511RLC', 'D206-642-512', 'D206-642-512RLC', 'D206-642-513', 'D206-642-514', 'D206-642-516', 'D206-642-518',

D206-642-612 USED Skidtube	Main Warehouse FG073	151336	Total: 8/10/2017	3.0000 1.0000			DAS 28 9-89	SEP 13 2017
D206-642-641 Repl. Skidtube, High Gear, Std Wearplates, Fits LH or RH, DART Tri-Bag Float Comp.	Main Warehouse FG073	127948	Total: 5/3/2016	1.0000 1.0000	QC21	CHG005	DAS 28 9-89	SEP 13 2017
	Main Warehouse FG073	130120	5/3/2016	1.0000	QC21	CHG005	DAS 28 9-89	SEP 13 2017
	Main Warehouse FG073	131245	5/3/2016	1.0000	QC21	CHG005	DAS 28 9-89	SEP 13 2017
	OFFSHORE FG	113627	5/3/2016	1.0000	QC21	CHG004		SEP 13 2017
	OFFSHORE FG	131246	5/3/2016	1.0000	QC21	CHG003		
D206-642-645 Standard Wearplates, High Float Gear 206A/B Fits LH or RH	Main Warehouse FG034	78261	Total: 6/30/2014	5.0000 2.0000	QC21	CHG001	DAS 28 9-89	SEP 13 2017
			Total:	2.0000				

Monday, August 14, 2017 8:54:03 AM

List Lots

Page 9 of 9

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date:	17.08.09	Job No.:	PH17-642-01	ADR Yes/No:		ADR Date:		ECN #:	17- 615
Product No.:	D206-642	Created By:	CV	Approved By:	DS				
Product Name:	Skidtube Installation	Checked By:	HS						

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	JLM	
Production Planning Man. / Production Planner	Y	ED/MP	
Supply Chain Director / Purchasing Manager	Y	RA/CL	
Production Engineering Coord.	Y	DD	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	SL	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS / ED	
QC Coordinator	Y	PD	
Customer Support	Y	SW / LM	
Customer Technical Support	Y	MB / ML	
Marketing	Y	WR	
Prod. Man. Solution Provider	Y	HM	

Reason for Change:

Updated to increase the allowable damage limits.

Documents Affected:

ICA-D206-642 Rev 7; D4366 Rev D; D4368 Rev C; D4369 Rev B; D4370 Rev C; D4371 Rev B; MDL-D206-642 Rev A; SR-D206-642-4 Rev A; D4720 Rev B.

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: _____

PAPERWORK UPDATE



PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	RP	Send copy of ICA-D206-642 Rev 7 to PHI	
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	Y	VS	MDL-D206-642 Rev A	17.06.26 VS
7	Update Document Record (DR)	N			
8	Update Product Compatibility Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		17.08.11
12	Update Product Specification Files (Bluefiles)	Y	KJ		17.08.11
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ		17.08.11
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ		17.08.11
17	Update / Verify Airworthiness Release Certificate Database	Y	KJ		17.08.11
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		17.08.11
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ		17.08.11
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

Update Routes/BOMS to reflect new drawing revisions.

OKAY TO USE OLD STOCK UNTIL DEPLETED

B165092

DONE

DATE
21
AUG

AUG 15 2017

ECN Verified & Complete: _____ Date: _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														